

Work Order ID 63751

Friday, November 12, 2010 11:27:07 AM



Page 1

Item ID: D4016-5

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Light Lid

Stop



Start Date: 11/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/11/12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr							
D4016	A							



Bandsaw

Jeaspa Bandsaw

100 Cut blanks as per folio

0.00

B. A. 10/11/25

6 Ø

110



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MACHINE AS PER FOLIO FA874 AND DWG
FOLIO REV: AA
DWG REV: A

B. A. 10/11/25

6 Ø

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

B. A 10/11/25

6 0

QC

Quality Control

130



QC8- Inspect parts - second check

0.00

10/11/25

6 0

QC

Quality Control

160

Identify as per dwg & Stock Location: WA

0.00

SA
10-11-30

6

Packaging

Packaging

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC21- Final Inspection - Work Order Release

0.00

CK 10/12/01 HJ

QC

Memo

0.00

MF

10-11-30

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NOTE: Date & initial all entries

Picklist Print

Friday, November 12, 2010 11:27:12 AM

Page 1

Work Order ID: 63751



Parent Item: D4016-5



Parent Item Name: Hinge Half, Light Lid

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X0.75 0		Purchased	No			100	f	19.0094	0.09	0.568421			

6061-T6 Bar .750 x .750



Location	Loc Qty	Loc Code	
MAT02	7.00935		
108877	1.62		
112567	2.9683		
114993	2.42105		0.5684 f+
MAT028	12		
114968	12		

J. A 10/11/25

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	03781
Description: Hinge Half, Light Lid	Part Number:	D4016-5
Inspection Dwg: D4016	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>J. A</u>	Audited by:	<u>OK</u>	Preliminary Approval:	
Date:	10/11/25	Date:	10/11/25	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	 

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

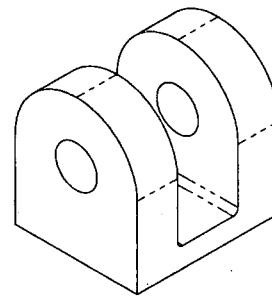
C

B

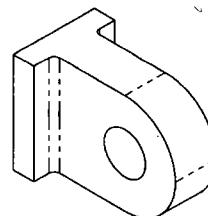
B

A

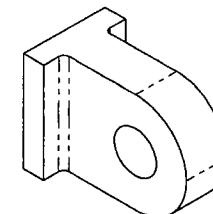
A



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDERS

NO. 63251

2/10/11-12

RELEASED
2010-02-16
MD

REV.	NEW ISSUE		JPH	10.01.29
DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	RR	DRAWING NO.	REV. A	
MFG. APPR.	RR	D4016	SHEET 1 OF 2	
APPROVED	RR	TITLE	SCALE	
DE APPR.	RR	BASKET HINGE	NTS	
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS EXPRESSED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITER PERMISSION FROM DART AEROSPACE LTD		

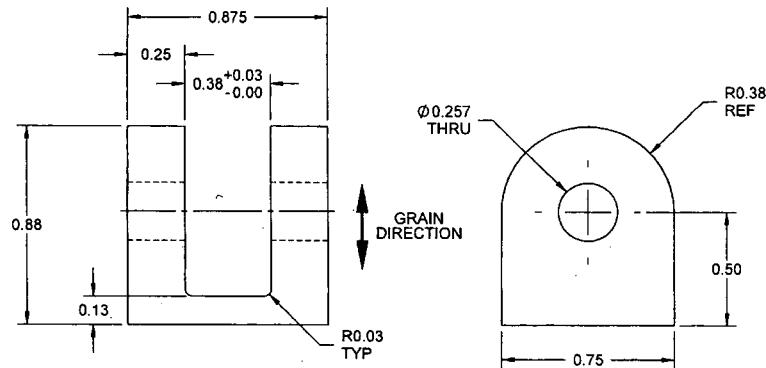
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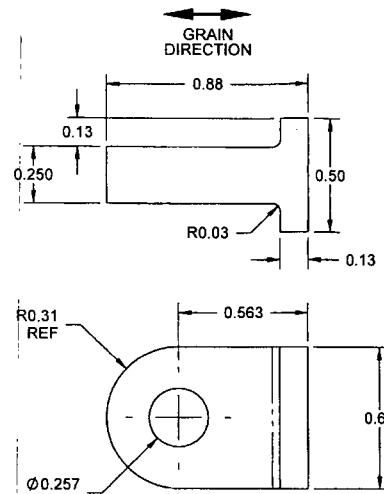
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE

NOTES:

- 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

u6 Q3731

RELEASED
2010-02-16
M

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	RR	DRAWING NO.
MFG. APPR.	RS	REV. A
APPROVED	RD	D4016
DE APPR.	MM	SHEET 2 OF 2
DATE	10.01.29	TITLE
		SCALE
		NTS
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